

1028-022 Blwy

Dart Aerospace Ltd.

Date: Thursday, 05/02/2009 3:44:50 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L /407 STEP ASSY, RH
Job Number : 45547A	
Estimate Number : 11703	
P.O. Number :	Part Number : D2724042 <i>BL</i>
This Issue : 05/02/2009 S.O. No. :	Drawing Number : D2724 REVC
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 39838A	Material :
Written By :	Due Date : 10/03/2009 Qty: 2 Um: Each
Checked & Approved By : <i>JUD 09.02.06</i>	
Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 1.0	D2622120C	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Qty Part # Description Batch:
 1 D2622-120C Extrusion *46910*

Check Material for any Dents or Defects

SAD 09-06-08

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

SAD 09-06-08 *(2)*

3.0	D2734	Step End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 206 Step Endplate
 Pick:
 Qty Part Number Description Batch
 2 D2734 End Cap *843535*

09.06.10 *2*

4.0	D34581	Step Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D3458-1 Plate *844007*

09.06.10 *2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:50 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 45547A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-3	Plate	344003

09-06-10 2

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch: M110130
M110972

Grind end cap welds flush

09-06-10 2

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-06-11 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/06/11 (2) RH

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09-06-12

2 RH

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-12

2 RH

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

09-06-12 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 45547A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: M110130

Grind end plate flush.

09.06.12 2
09.06.12 2

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09.06.15

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/15 X2RH

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

X2

Touch up Alodine

UMD 09/06/15

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B 110199

-SPRAY PAINT DELFLEET BLUE

B 110077

-CLEAR DELFLEET

B 110899

M 09 06 15 (2)

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

09/06/16 (2)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

UMD 09/06/16 (2)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/06/16 (2)

Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



~~SA~~

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

RRD 45547

9/4/17

SP

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

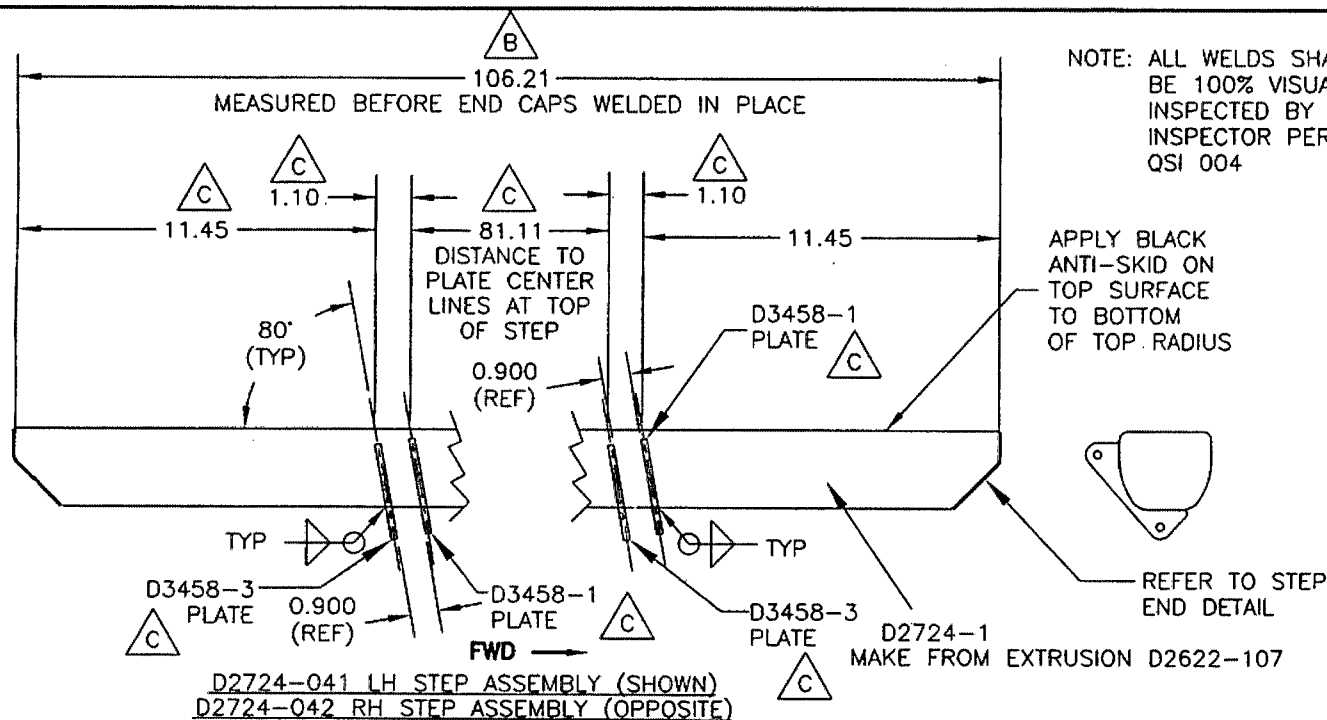
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

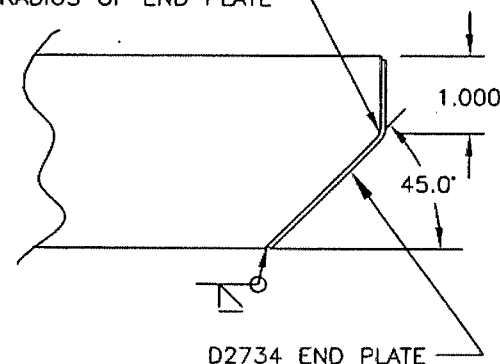
DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04		NEW ISSUE
	B	98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES
	C	05.09.19		RE-DESIGN, ADD D3458-1/-3
TITLE				206L/407 STEP ASSEMBLY
SCALE				NTS
SHEET 1 OF 1				

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